

Monday, 2/27/2006 1:27:45 PM
Linda Lacelle

Process Sheet

Split - 1

Part : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING ASSEMBLY
 Part Number : 25940 - 1
 Drawing Number : 10181
 Project Number : N/A
 Drawing Revision : 2/27/2006 S.O. No. : N/A
 Material : NC
 Due Date : N/A Type : PURCHASED PARTS
 Qty: 32 - 36 Units Each
 Approved By : SEE COMMENT BELOW
 Comment : SEE ABOVE USER & DATE
 Est. E 02.07.08 Re-format KJH

J Number



Seq.

Machine Or Operation:

Description :

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 60006168

Gas Spring P/N SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

D2153P

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 36.0000 Each(s)
GAS SPRING ASSEMBLY

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

Process Sheet

CU-DAR001 rt Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

25940

Part Number: D2153



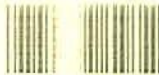
Seq

Machine Or peration:

Description :

D30153

Lock Nut



Qty: 1 000 Each(s)/Unit Total: 72.0000 Each(s)

Lock Nut

Pick:

Qty	Part	umber	Description	Batch
2	D30	3	Lock nut	B2349

AN960JD516

Washer



Qty: 2 000 Each(s)/Unit Total: 72.0000 Each(s)

Washer

Pick:

Qty	Part	umber	Description	Batch
2	AN9	JD516	Washer	M18100

SL69BS

Ball Stud



Qty: 2 000 Each(s)/Unit Total: 72.0000 Each(s)

Ball Stud

Pick:

Qty	Part	umber	Description	Batch
2	SL6	BS	Stud	M16948

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

SB 06/03/08

32

QC5

INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP

06-03-08

32

PACKAGING 1

PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Identify and Stock

Location: ST2B

C'del 103/09 (32)

Process Sheet

CU-DARCO Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

25340

Part Number: D2153



Machine : Operation :

Description :

DC

DOCUMENT CONTROL



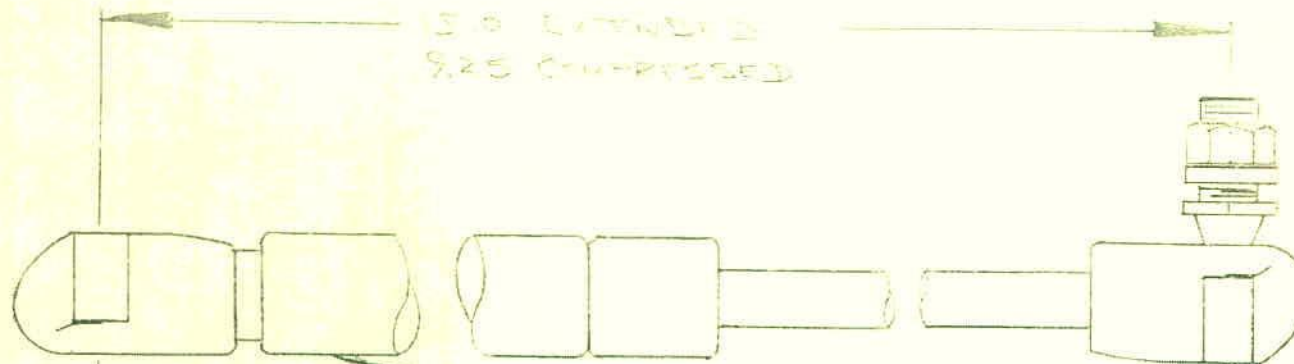
ent: DOCUMENT CONTROL
Inspection Level 21

DP 06/03/09

Job :



u 06-03-09



SL-13-10 SPRING (SPRING LIFT CORD)

SL69-B5 STUD (SPRING LIFT CORD)

AN 960-516 WASHER

5/16-18 UNC 50000 PSI 100' LONG
D3015-3



RELEASED

01 05 07 CHANGE TO D3015-3 SL 13-10 WAS SL 32-17	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR	
	DRAWN			BASIC CODE		CONTRACT NO		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA			
	APPROVED			D-DIMPLE D-DIMPLE NO OF SHEETS C-COUNTERSINK		DATE 17.2.8.72					
	DESCRIPTION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES 0.11 MAX 4. THREADS PER INCH 3-7742 5. HOLES PER AND 10387		1. TOLERANCES — EX & D30 2. ANGLES 1 1/4" 3. PARALLELISM 0.0025 4. ECCENTRICITY 0.005 MAX 5. SYMMETRY ABOUT ALL M/T CENTRE LINES 0.005		LENGTH DASH NO W-SPOTWELD BASIC CODES B-MINIMUM TREAD BE-HMS 704 2540		DESIGN 11A-11111 STRESS 7.400 7.400		TITLE CAP 2 SPRING ASSEMBLY	
	OR CHANGE					CHECKED 7.400 7.400		COCK DZ153		REV A	
REPORT ALL DISCREPANCIES — DO NOT SCALE											

